

Date: Tuesday, 4/25/2006 7:35:41 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOUBLER |
| Job Number | : 26797 | | |
| Estimate Number | : 11473 | | |
| P.O. Number | : N/A | Part Number | : D3140301 |
| This Issue | : 4/25/2006 S.O. No. : N/A | Drawing Number | : D3140 REV D1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : D1 |
| Previous Run | : 25734 | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 5/1/2006 |
| Checked & Approved By | : <u>06.04.25</u> | Qty: | 1 Um: Each |
| Comment | : Est. A06.11.06 New issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 2.9166 sf(s)/Unit Total : 2.9166 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick(
 M6061T6S.063)
 Batch: M19326
 Identify as D3140-301

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR Water Jet
 Cut blanks: 48.700" x 7.350"

ORD rev: D1
 Dwg rev: D1

M 06.04.25 (4)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3140-301 as per Folio FA316 and Dwg D3140
 Deburr

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

PC / M

06.04.25

(4)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

PC

06.04.25

(4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Q Date: 06/01/28

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 26797

Part Number: D3140301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Mel F.

06-04-27

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 06-04-27

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

U 06-04-27

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/28

Job Completion



U 06-04-28

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
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| DESIGN DS | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3140 | REV. D SHEET 1 OF 7 |
| DATE 05.11.23 | | TITLE DOOR | SCALE NTS |
| A | 02.04.18 | NEW ISSUE | |
| B | 03.01.23 | REMOVE -65/-81/-83; ADD -301/-303 | |
| C | 04.11.08 | CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106° | |
| D | 05.11.23 | ADD -103/-104/-105/-106; REMOVE -67 | |
| DI | 06.03.31 | 1.75 WAS 1.88; 4.75 WAS 4.13 | |

RELEASED
05.12.01

| QTY -05 | QTY -06 | QTY -07 | QTY -08 | QTY -09 | QTY -10 | PART NUMBER | DESCRIPTION |
|------------|------------|------------|------------|------------|------------|--------------|------------------|
| X | | | | | | D3140-05 | DOOR |
| | X | | | | | D3140-06 | DOOR |
| | | X | | | | D3140-07 | DOOR |
| | | | X | | | D3140-08 | DOOR |
| | | 1 | | X | | D3140-09 | DOUBLER ASSEMBLY |
| | | | 1 | | X | D3140-10 | DOUBLER ASSEMBLY |
| 3 | 3 | | | | | D3140-57 | PAD |
| 1 | 1 | | | | | D3140-59 | PAD |
| 2 | 2 | | | | | D3140-61 | PAD |
| 2 | 2 | | | | | D3140-63 | PAD |
| | | 1 | 1 | | | D3140-69 | PAD |
| | | 1 | 1 | | | D3140-71 | PAD |
| | | 1 | 1 | | | D3140-73 | PAD |
| | | 1 | 1 | | | D3140-75 | PAD |
| | | 1 | 1 | | | D3140-77 | PAD |
| | | 1 | 1 | | | D3140-79 | PAD |
| | | | | 1 | 1 | D3140-85 | ANGLE |
| 1 | 1 | | | | | D3140-87 | DOUBLER |
| | | | | 1 | 1 | D3140-89 | DOUBLER |
| | | 1 | | | | D3140-91 | DOUBLER |
| | | | 1 | | | D3140-92 | DOUBLER |
| 3 | 3 | | | | | D3140-95 | DOUBLER |
| 1 | | | | | | D3140-97 | DOUBLER |
| | 1 | | | | | D3140-98 | DOUBLER |
| | | 1 | 1 | | | D3140-99 | DOUBLER |
| | | 2 | 2 | | | D3140-101 | DOUBLER |
| | | 1 | | | | D3140-103 | DOUBLER |
| | | | 1 | | | D3140-104 | DOUBLER |
| | | 1 | | | | D3140-105 | DOUBLER |
| | | | 1 | | | D3140-106 | DOUBLER |
| 1 | 1 | | | | | D3140-241 | DOUBLER |
| 1 | | 1 | | | | D3140-301 | DOUBLER |
| | 1 | | 1 | | | D3140-303 | DOUBLER |
| | | | | 5 | 5 | MS20426AD3-4 | RIVET |

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| DATE 05.11.23 | | TITLE DOOR | SCALE NTS |

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

| PART | TOOL |
|-----------|---------------|
| D3140-05 | B30-23000-01T |
| D3140-06 | B30-23000-02T |
| D3140-07 | B30-23000-03T |
| D3140-08 | B30-23000-04T |
| D3140-57 | B30-23000-57T |
| D3140-61 | B30-23000-61T |
| D3140-63 | B30-23000-63T |
| D3140-69 | B30-23000-69T |
| D3140-71 | B30-23000-71T |
| D3140-73 | B30-23000-73T |
| D3140-75 | B30-23000-75T |
| D3140-77 | B30-23000-77T |
| D3140-79 | B30-23000-79T |
| D3140-89 | D3140-89T1 |
| D3140-301 | D3140-301T1 |
| D3140-303 | D3140-303T1 |

RELEASED
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

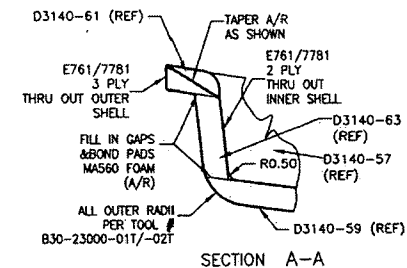
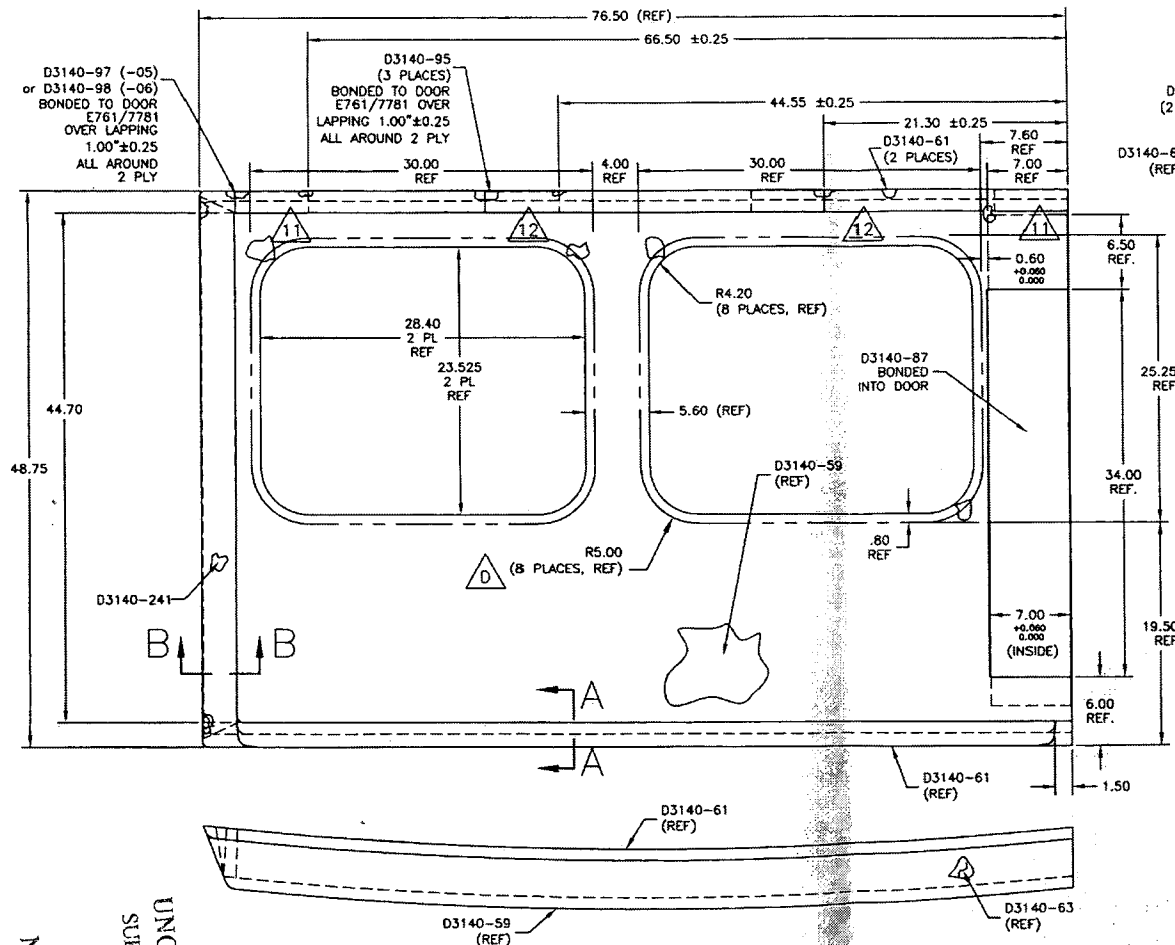
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

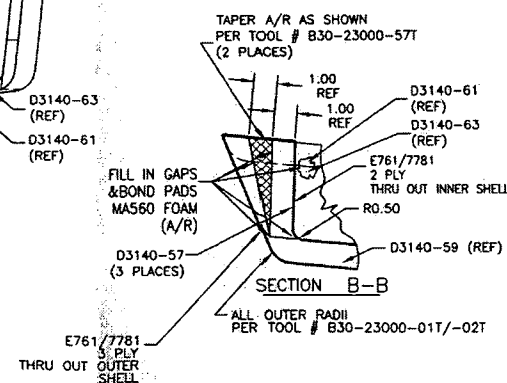
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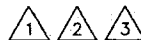
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OS 11-01-01



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

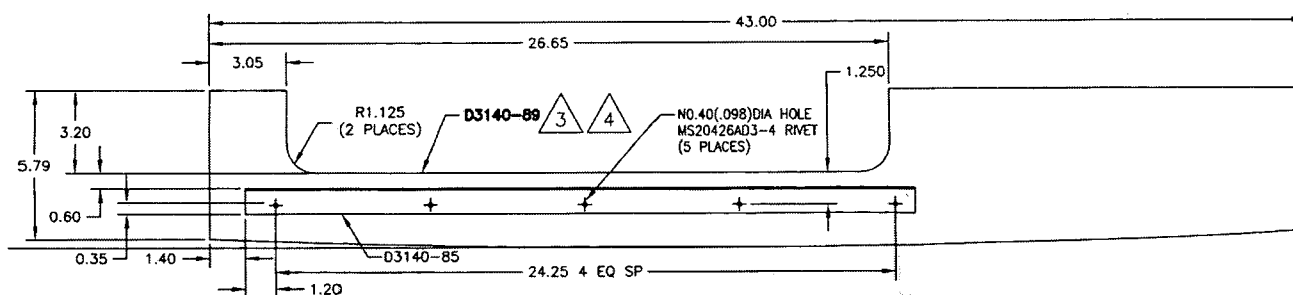


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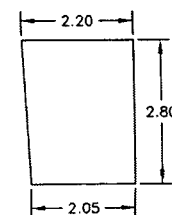
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| DATE 05.11.23 | TITLE DOOR | SCALE NTS | |

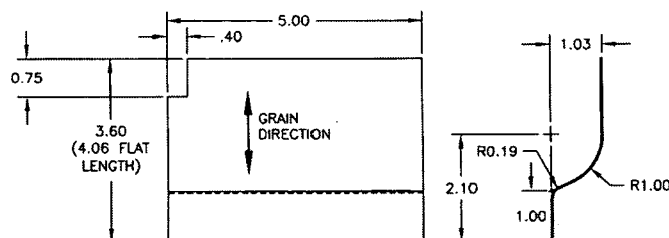
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D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

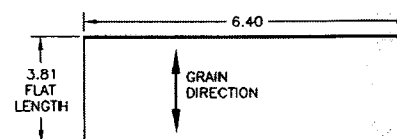


D3140-101 DOUBLER (4)
 (REPLACES PREMIER P/N B30-23000-101)

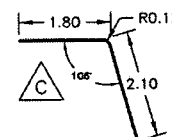


D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

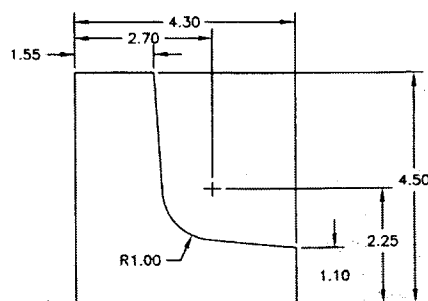
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 (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



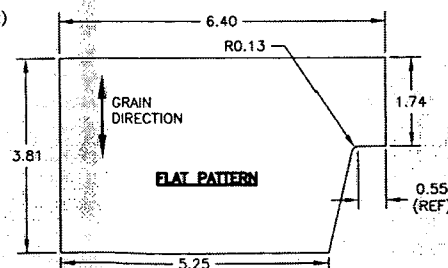
D3140-95 DOUBLER (4)
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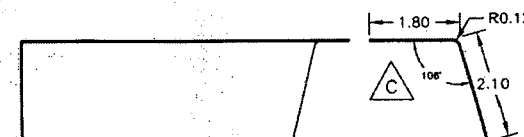
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D3140-98 DOUBLER (4)
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)



BEND DETAIL

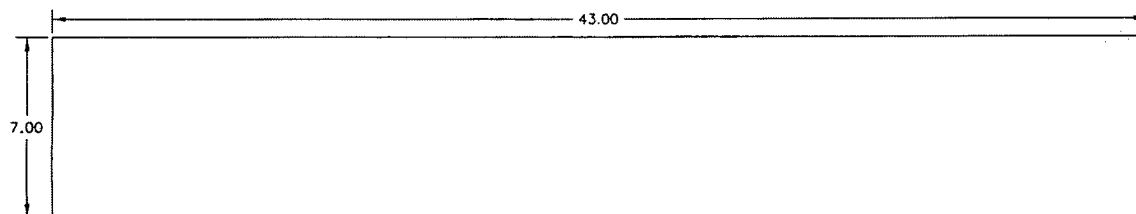
D3140-97 DOUBLER (4)
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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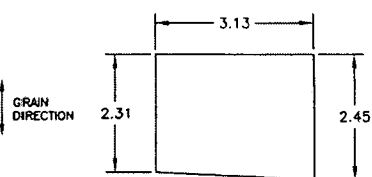
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| DATE 05.11.23 | TITLE DOOR | SCALE NTS | |

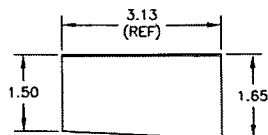
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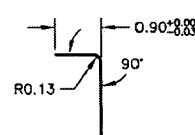
D3140-87 DOUBLER $\triangle 4$
(REPLACES PREMIER P/N B30-23000-87)



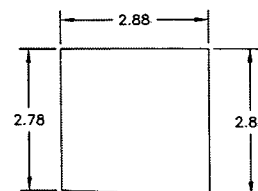
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



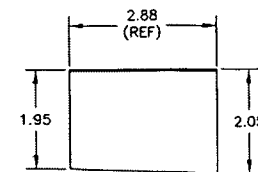
D3140-105 DOUBLER
D3140-106 OPPOSITE



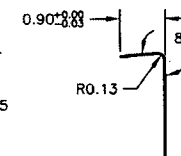
GRAIN DIRECTION



D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

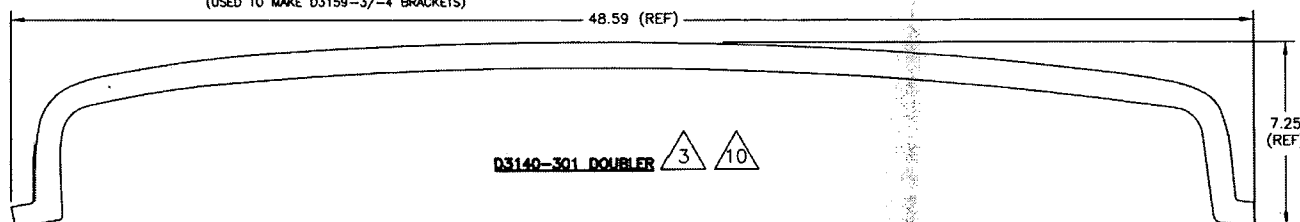


D3140-103 DOUBLER
D3140-104 OPPOSITE

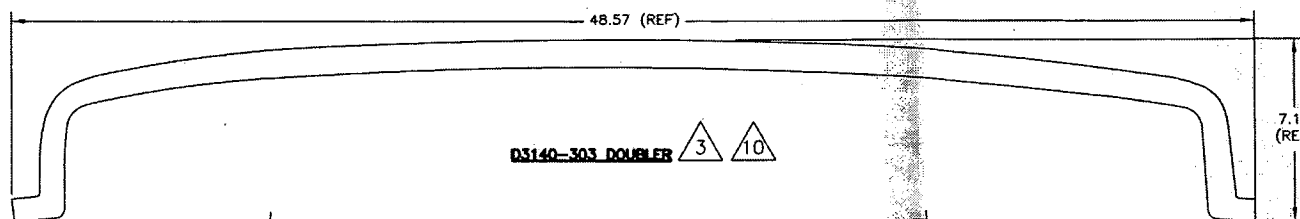


$\triangle 4$ $\triangle D$

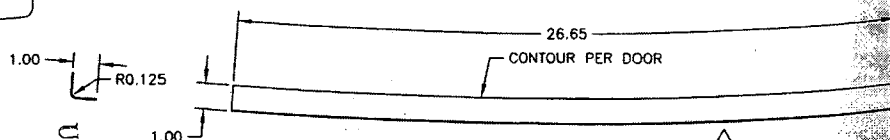
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER $\triangle 3$ $\triangle 10$



D3140-303 DOUBLER $\triangle 3$ $\triangle 10$

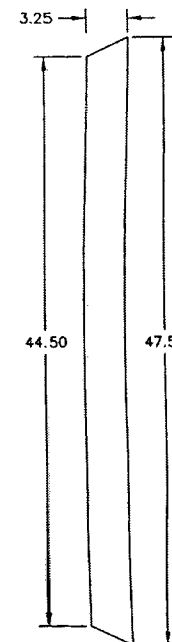
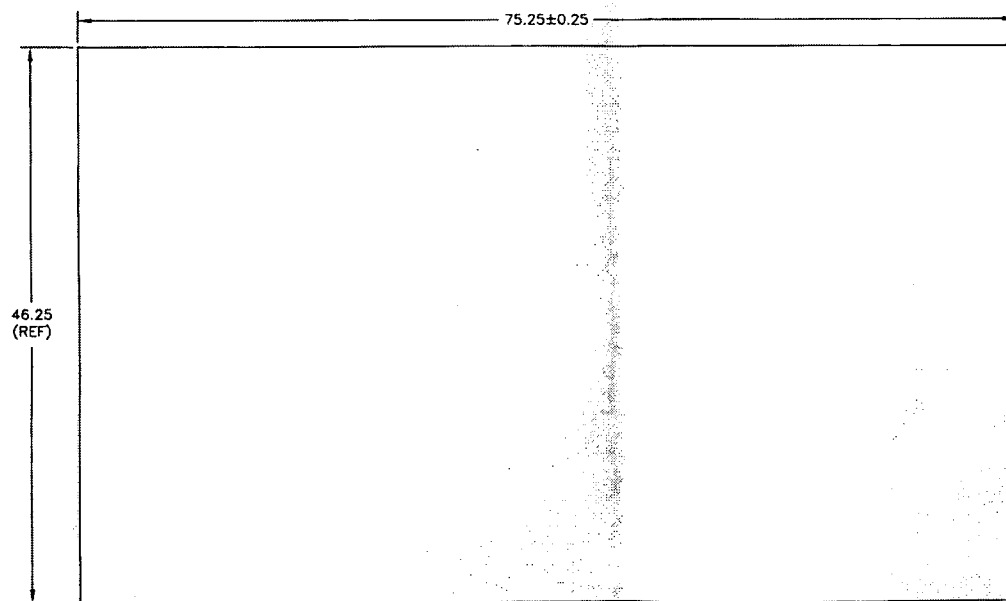
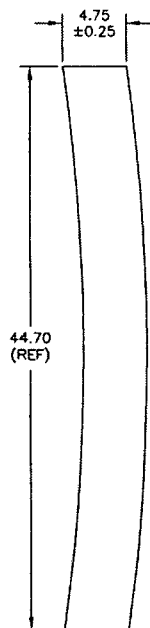
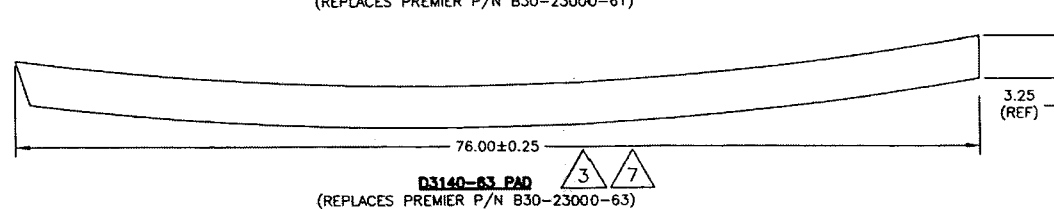
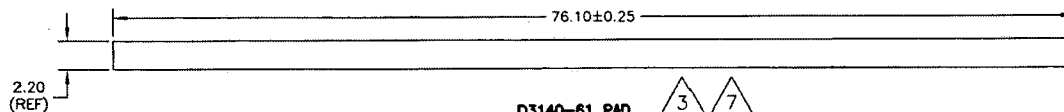


D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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05.11.23

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| DATE 05.11.23 | | DRAWING NO. D3140 | | | | |
| | | TITLE DOOR | | | | |

